

SS 303 ~~4500~~
-4500

Work Order ID 85426

June-07-12 2:54:43 PM

85426

Page 1

Item ID: D3403-5

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bushing

Start Date: 07/06/2012 Start Qty: 60.00

60

Cust Item ID:

Required Date: 14/06/2012 Req'd Qty: 60.00

60

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/07 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3403

D

100

0.00

100

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1- Turn as per Folio FA925 & Dwg D3403

Folio Rev:

Dwg Rev: D

2-Deburr

SL 12-06-11

60

0

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

SL 12-06-11

60

0

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

amk 12/06/11

60

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 85426

85426

Page 2

June-07-12 2:54:43 PM

Item ID: D3403-5

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Bushing

Stop ***NS2***

Start Date: 07/06/2012 Start Qty: 60.00

60

Cust Item ID:

Required Date: 14/06/2012 Req'd Qty: 60.00

60

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location STYZ

0.00

130

Packaging

Memo

0.00

Packaging

60

Sae 12/06/11

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/06/11 MF

12-06-11

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 85426

85426

Parent Item: D3403-5

D3403-5

Parent Item Name: Bushing

Start Date: 07/06/2012

Required Date: 14/06/2012

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP REV:A NEW ISSUE 10-04-23 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.750		Purchased	No			100	f	107.8560	0.25	15.78947			

M303R0 750

303 Round Bar 0.750

SL 12-06-11

Location

Loc Qty

Loc Code

MAT028

107.856

117328

13.242

117798

4.004

118509

4.08

119346

0.645

120145

10.566

121070

1.1

121157

25.619

121282

0.6

121728

48

**6*
**15.2*

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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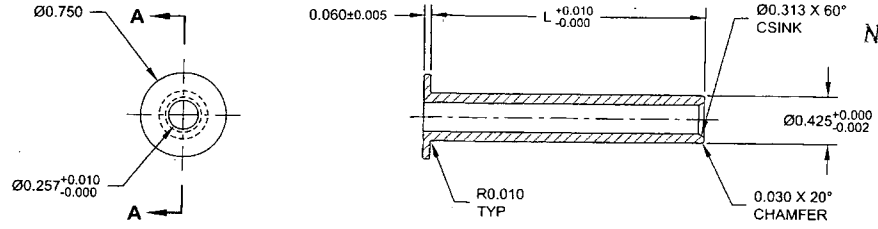
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 85426 MLJ

12/06/08



SECTION A-A

D3403-X BUSHING

DART P/N	L	WEIGHT (lbs)
D3403-1	2.416	0.07
D3403-3	2.165	0.06
D3403-5	2.440	0.07

RELEASED
2011-10-31

NOTES:

- 1) MATERIAL: AISI 303 SS ROUND BAR
PER ASTM A582
REF. DART SPEC. M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: PER TABLE

D	FOR -5, 2.440 WAS 2.500 (PER PAR 11-125)	XDF	11.10.28
C	REFORMAT TO CURRENT STD PER QSI 043; ADDED D3403-5. TOL WAS +0.005/-0.000. REASON: PAR#10-029	MB	10.04.21
B	ADD COUNTERSINK	PH	06.01.23
A	NEW ISSUE	PH	05.03.07
REV.	DESCRIPTION	BY	DATE
DESIGN	<div>5</div> <div>DART AEROSPACE LTD</div> <div>HAWKESBURY, ONTARIO, CANADA</div>		
DRAWN		XDF	
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.10.28	COPYRIGHT © 2005 BY DART AEROSPACE LTD	
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